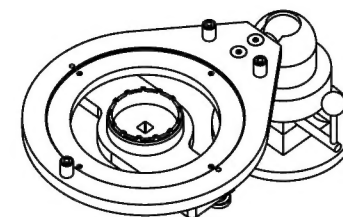
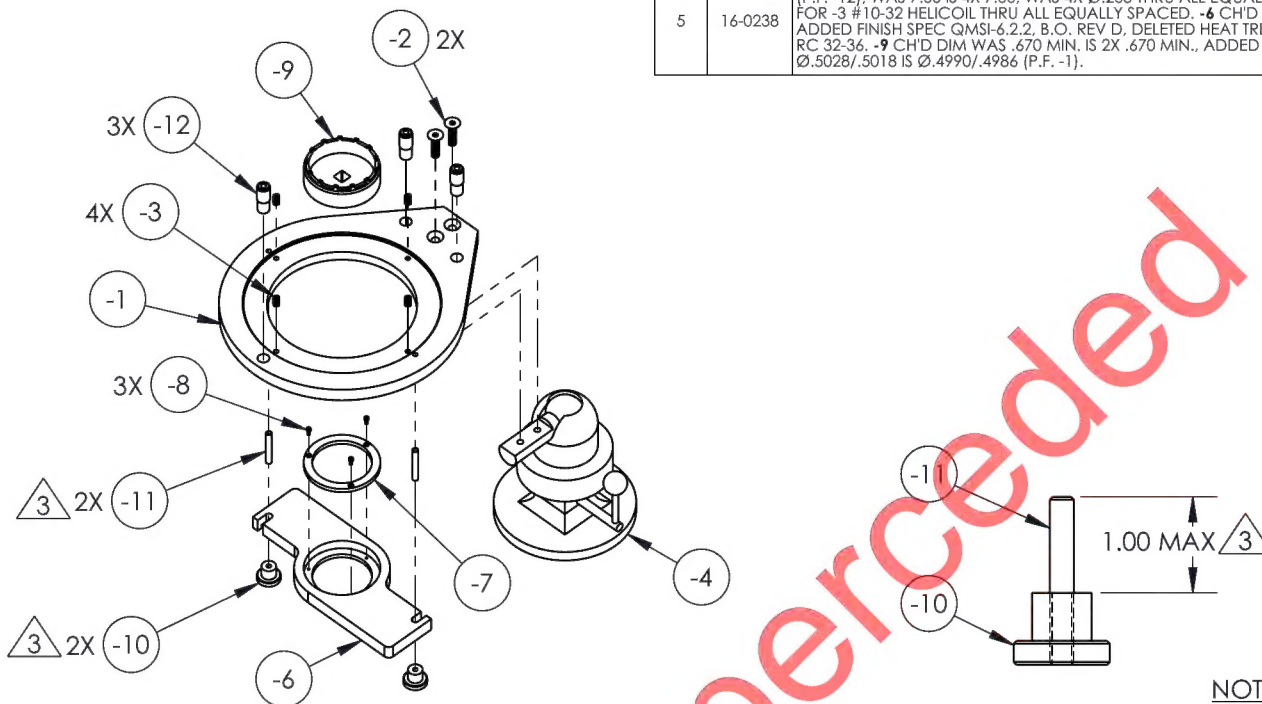


This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0210	-1 CH'D MATERIAL WAS 2024-T4 IS 6061, CH'D HOLE WAS 4X 5/16-18 TAP THRU IS 4X Ø.203 TRHU FOR -3 HELI-COIL. -6 CH'D MATERIAL WAS 2024-T4 IS 6061. -7 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE. -9 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE, CH'D MATERIAL WAS 4340 IS 4140/4142. -10 CH'D TO BUYOUT MCMASTER-CARR #5125K22. -12 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE. ADDED Δ 3 NOTE.	8/18/2015	RJC	JAG
5	16-0238	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIM WAS 3X Ø.4981/.4971 IS 3X Ø.4981/.4971 (P.F. -12), WAS 7.00 IS 4X 7.00. WAS 4X Ø.203 THRU ALL EQUALLY SPACED FOR -3 HELICOIL IS 4X TAP FOR -3 #10-32 HELICOIL THRU ALL EQUALLY SPACED. -6 CH'D DIM WAS 2X .50 IS 3X .50. -7, -9, -12 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. DELETED HEAT TREAT RC 32-36. -7 DELETED HEAT TREAT RC 32-36. -9 CH'D DIM WAS .670 MIN. IS 2X .670 MIN., ADDED DETAIL D. -12 CH'D DIM WAS Ø.5028/.5018 IS Ø.4990/.4986 (P.F. -1).	11/30/2016	RJC	JAG



UNDER REVIEW
URF 19-753 19.05.30 (VM)

NOTES:

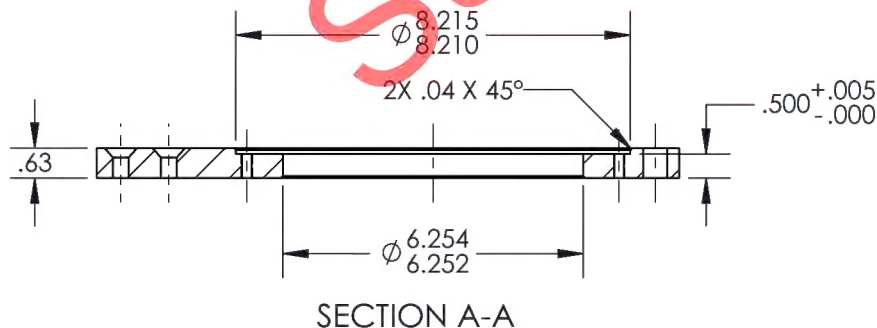
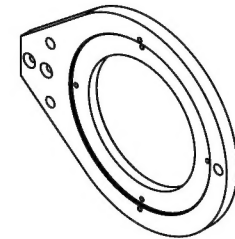
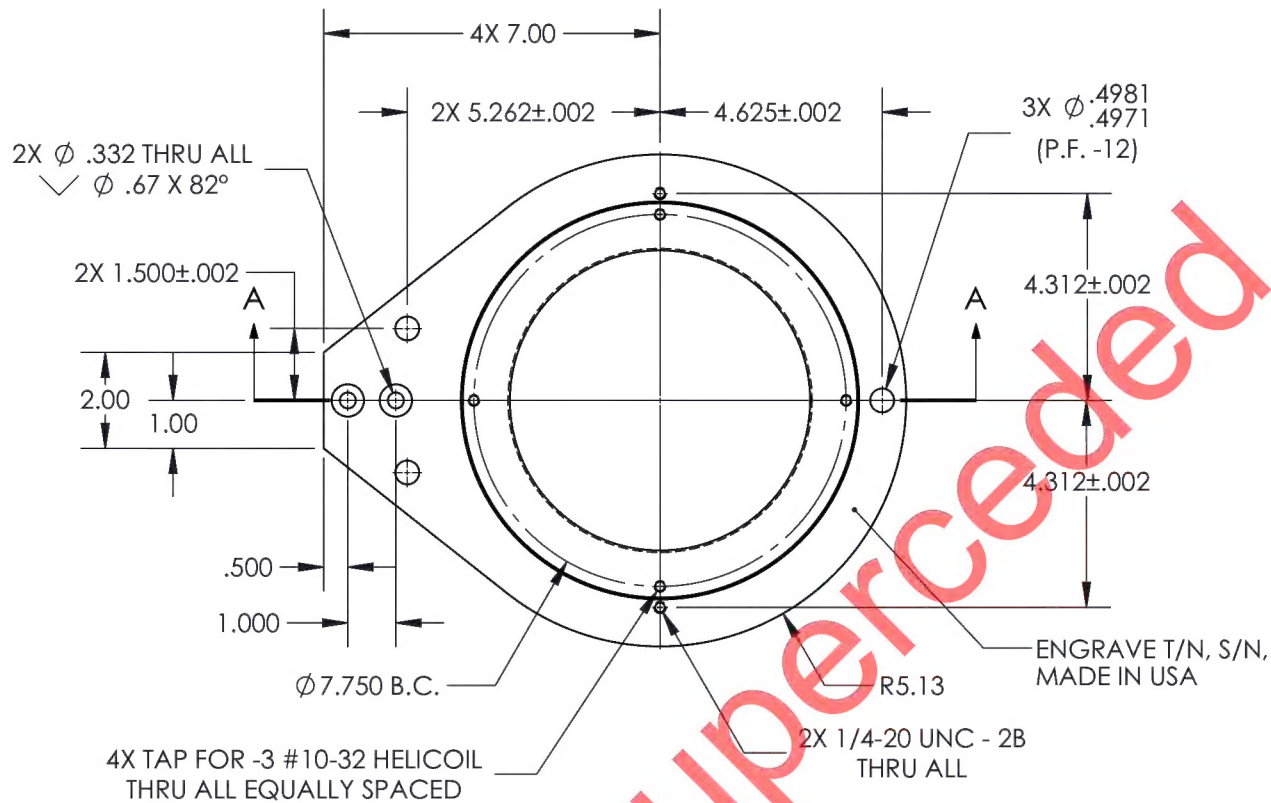
- REF. ROLLS ROYCE T/N: 6799955.
- RB6799955-100 ASSY, CONSISTS OF ALL ITEMS LESS ITEM -4.
- Δ ASSEMBLE -10 AND -11 AND LOCTITE THREADS.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PLATE	6061		2
		B/O	-2	2	FLAT HEAD SOCKET CAP SCREW	STEEL	5/16-18 UNC X 1-1/4 (MCMASTER-CARR #91253A585)	1
		B/O	-3	4	INSERT	S.S.	10-32 INTERENAL (MCMASTER-CARR #91732A726)	1
		B/O	-4	1	POWER ARM		(WILTON #301)	1
			-6	1	WRENCH RETAINER	6061		3
			-7	1	SPACER	DOM		4
		B/O	-8	3	SOCKET HEAD CAP SCREW	STEEL	4-40 UNC X 1/4 (MCMASTER-CARR #91251A106)	1
			-9	1	WRENCH	4140/4142		5
		B/O	-10	2	KNOB	BRASS	1/4-20 UNC X Ø1 O.D. (MCMASTER-CARR #5125K22)	1
		B/O	-11	2	STUD	STEEL	1/4-20 UNC X 1-3/4 (MCMASTER-CARR #95475A547)	1
			-12	3	LOCATOR	1018/1020 CR		6

DART AEROSPACE	
TITLE FIXTURE-ASSEMBLY, TURBINE	
DWG NO. RB6799955	REV 5
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .015 ANGLES ± 1° .X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	ROLLS ROYCE
APPROVED: GILBERT	
SCALE 1:4	DATE 8/18/2015
SHEET 1 OF 6	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0210	-1 CH'D MATERIAL WAS 2024-T4 IS 6061, CH'D HOLE WAS 4X 5/16-18 TAP THRU IS 4X Ø.203 TRHU FOR - 3 HELI-COIL.	8/18/2015	RJC	JAG
5	16-0238	-1 CH'D DIM WAS 3X Ø.4981/.4971 IS 3X Ø.4981/.4971 (P.F. -12). WAS 7.00 IS 4X 7.00, WAS 4X Ø.203 THRU ALL EQUALLY SPACED FOR -3 HELICOIL IS 4X TAP FOR -3 #10-32 HELICOIL THRU ALL EQUALLY SPACED.	11/30/2016	RJC	JAG



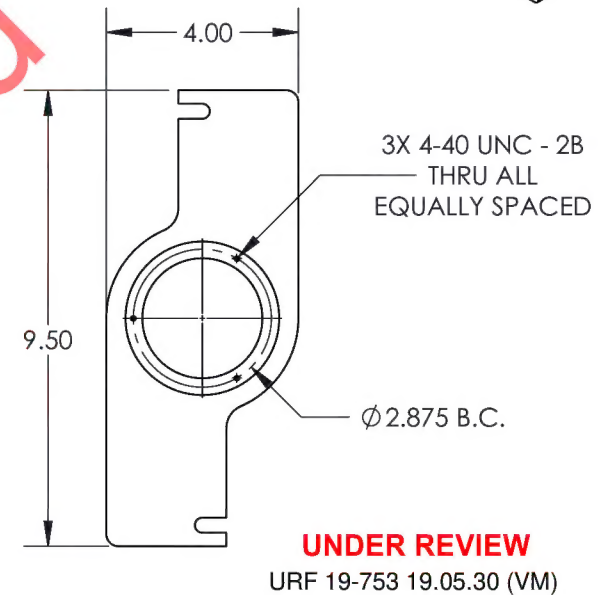
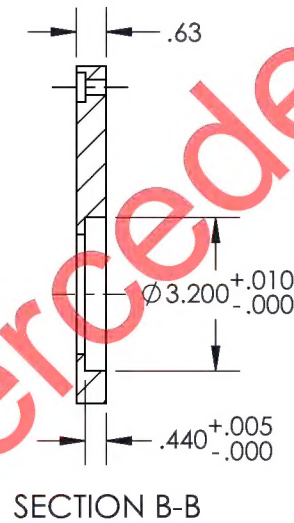
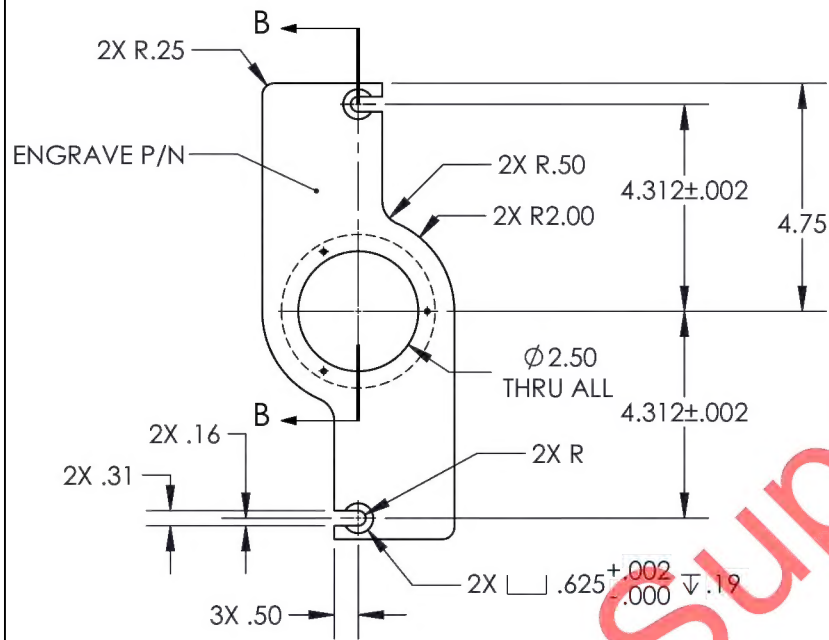
(-1)
PLATE

UNDER REVIEW
URF 19-753 19.05.30 (VM)

DART AEROSPACE	
TITLE FIXTURE-ASSEMBLY, TURBINE	
DWG NO. RB6799955-1	REV 5
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX ± .010 FRACTIONS ± 1/8
SPEC MIL-A-8625, TYPE II, CLASS I	.XX ± .015 ANGLES ± 1°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:4	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 8/18/2015	USED ON MODEL
SHEET 2 OF 6	ROLLS ROYCE

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0210	-6 CH'D MATERIAL WAS 2024-T4 IS 6061.	8/18/2015	RJC	JAG
5	16-0238	-6 CH'D DIM WAS 2X .50 IS 3X .50.	11/30/2016	RJC	JAG



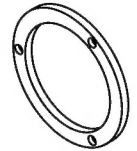
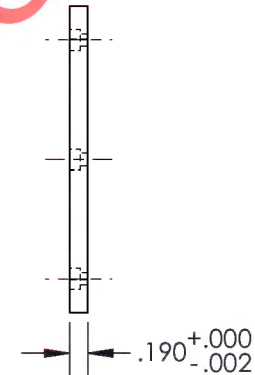
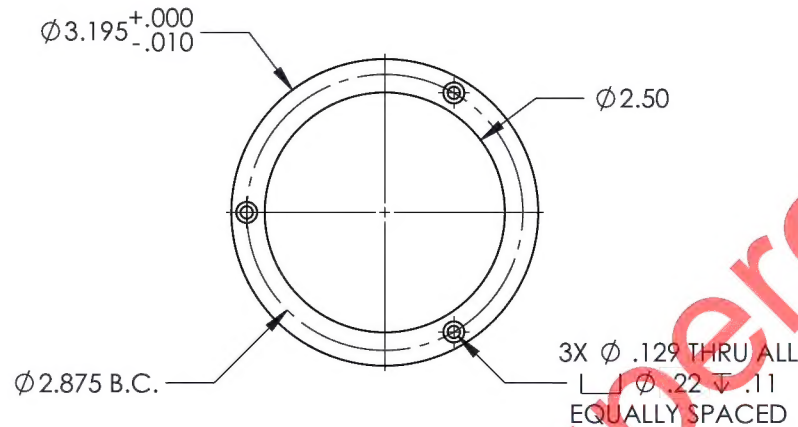
UNDER REVIEW
URF 19-753 19.05.30 (VM)

WRENCH RETAINER

DART AEROSPACE	
TITLE FIXTURE-ASSEMBLY, TURBINE	
DWG NO. RB6799955-6	REV 5
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .015 ANGLES ± 1°
SPEC MIL-A-8625, TYPE II, CLASS I	.X ± .1 SURFACES = 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	ROLLS ROYCE
SCALE 1:4	DATE 8/18/2015
SHEET 3 OF 6	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0210	-7 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE.	8/18/2015	RJC	JAG
5	16-0238	-7 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, DELETED HEAT TREAT RC 32-36.	11/30/2016	RJC	JAG



UNDER REVIEW

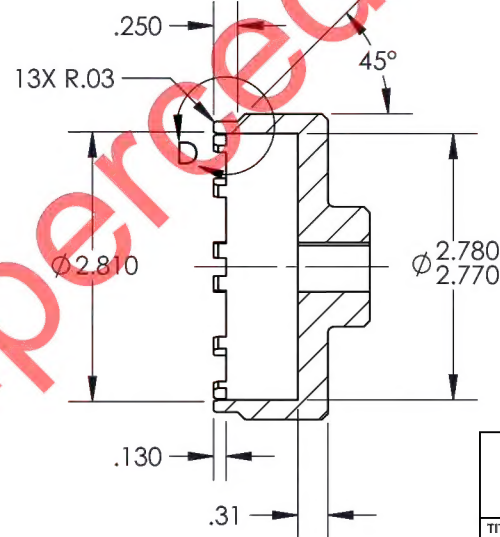
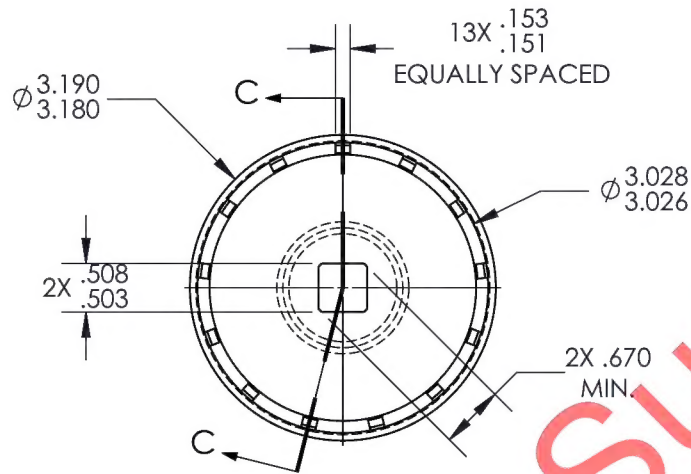
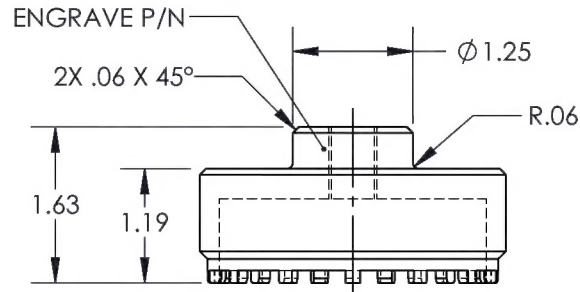
URF 19-753 19.05.30 (VM)

(-7)
SPACER

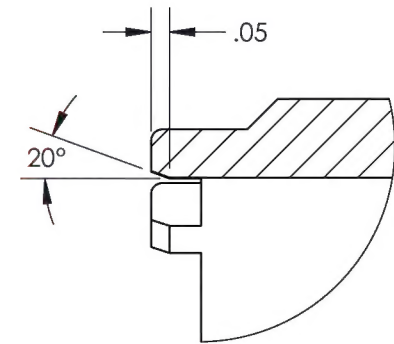
DART AEROSPACE	
TITLE FIXTURE-ASSEMBLY, TURBINE	
DWG NO. RB6799955-7	REV 5
MAT'L DOM	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX \pm .015 ANGLES \pm 1°
DRAWN BY: CLOUGH	.X \pm .1 SURFACES = 125
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 8/18/2015	USED ON MODEL
SHEET 4 OF 6	ROLLS ROYCE

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0210	-9 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE, CH'D MATERIAL WAS 4340 IS 4140/4142.	8/18/2015	RJC	JAG
5	16-0238	-9 CH'D DIM WAS .670 MIN. IS 2X .670 MIN., ADDED DETAIL D, ADDED FINISH SPEC QMSI-6.2.2, B.O.	11/30/2016	RJC	JAG



SECTION C-C



DETAIL D
SCALE 2 : 1

-9

WRENCH

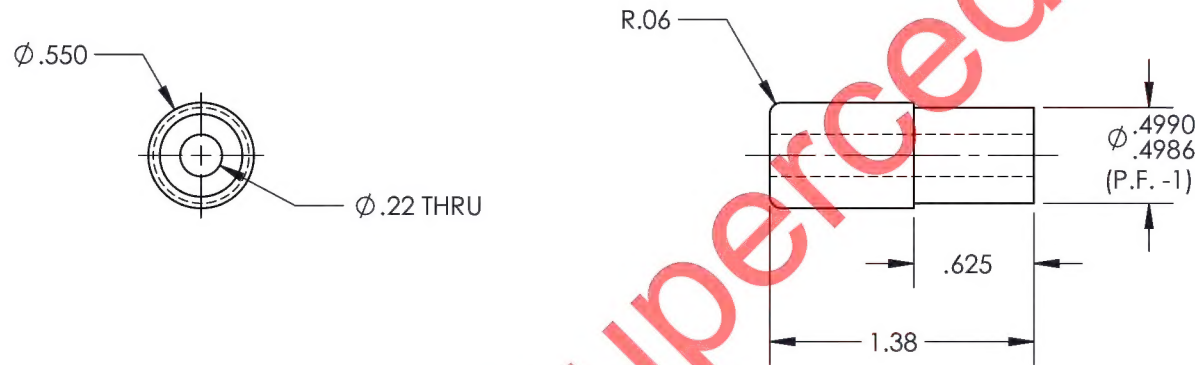
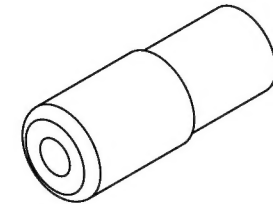
UNDER REVIEW

URF 19-753 19.05.30 (VM)

DART AEROSPACE	
TITLE FIXTURE-ASSEMBLY, TURBINE	
DWG NO. RB6799955-9	REV 5
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 32-36	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .015 ANGLES ± 1°
FINISH BLACK OXIDE	.X ± .1 SURFACES = 125✓
SPEC QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	ROLLS ROYCE
APPROVED: GILBERT	
SCALE 1:2	DATE 8/18/2015
	SHEET 5 OF 6

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0210	-12 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE.	8/18/2015	RJC	JAG
5	16-0238	-12 CH'D DIM WAS Ø.5028/.5018 IS Ø.4990/.4986 (P.F. -1). ADDED FINISH SPEC QMSI-6.2.2, B.O.	11/30/2016	RJC	JAG



UNDER REVIEW
URF 19-753 19.05.30 (VM)

(-12)

LOCATOR

DART AEROSPACE	
TITLE FIXTURE-ASSEMBLY, TURBINE	
DWG NO. RB6799955-12	REV 5
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .015 ANGLES ± 1°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	ROLLS ROYCE
SCALE 1:1	DATE 8/18/2015
SHEET 6 OF 6	